



Dart Aerospace Ltd.
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D4034-043

Job Sheet 199773



Part No: D4034-043

Job Qty: 4 pcs

Part Name: Fwd Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/30/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	9/20/19	9/20/19	0.00	1.60	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4	DAS 24	10/02/2019
							Large Fab - 5	9-89	
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	4 pcs	9/20/19	9/20/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		a
							QC 9 - 9		
120	QC 5	4 pcs	9/20/19	9/20/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



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Container No: S219225



Part: D4034-043

Job No: 199773

Serial No/Batch: S219225

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/02/19

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			QC 5 - 9	
			QC 5 - 50	2
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
130 Packaging 3-1 - Stock - B4B 4 pcs	9/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	2
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
140 QC 21 - SA 4 pcs	9/20/19	0.00 0.00	QC 21 - SA - 21	DAG 21
			QC 21 - SA - 70	9-59 OCT 03 2019
			QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 139015) 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld Descriptions: bushing in rib as per dwg

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: WA004) LOCATION: WA004-5

140 - (QC21- Final Inspection - Work Order Release)

012223

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	100-Large Fab - Basket - 1	5212094
D4021-9	Bushing	16 pcs (4 ea)	100-Large Fab - Basket - 1	5210140
D4034-1	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5214565
D4034-3	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5205377

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D4021-7	4	0	0
	D4021-9	16	187	0
	D4034-1	4	22	0
	D4034-3	4	22	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

Job: _____		DISPOSITION		DEPARTMENT/PROCESS						MRRB (QS1042)													
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality													
Date :	Sequence #:	QTY Affected :										MRRB (QS1042)											
Description Work Order Deviation												Disposition											
												Completed By											
												Lead hand / Supervisor											
												QC / QA Coordinator											
Root Cause												FAULT CATEGORY											
Operator												Positioned Wrong											
Manufacturing Process												Outside Tolerance											
Equip/Tooling												Drawing											
Handling/Preservation												Finish											
Material												Part Lost/Missing											
Product Improvement												Misread											
Process Improvement																							
Human Factors																							
Pressure/Forced												Power Loss/Surge											
Bending												Folio/Program											
Crushing												Grain Direction											
Cracks												Weld											
Crimp/Kink/Ripple/Wave/Twist												Wrong Stock Pulled											
Marks/Chatter												Out of Sequence											
Mislabeled												Off-set/Set-up											
Other/Details:																							